

Feature	Value	Unit	Testmethod
PHYSICAL PROPERTIES			
Density	1,14	g/cm ³	ISO 1183
Viscosity	--	Pas	--
MECHANICAL PROPERTIES			
Flexural modulus at +23°C	3000 (1700)	MPa	ISO 178
Maximum flexural strength	136 (70)	MPa	ISO 178
Maximum tensile strength	85 (60)	MPa	ISO 527-2
Elongation at break	--	%	ISO 527-2
Elongation at yield	6 (20)	%	ISO 527-2
IMPACT PROPERTIES			
Impact strength	--	--	--
Notched Charpy at +23°C	6 (15)	kJ/m ²	ISO 179
Notched Charpy at -20°C	(5)	kJ/m ²	ISO 179
Unnotched Charpy at +23°C	NB (NB)	kJ/m ²	ISO 179
Unnotched Charpy at -20°C	(NB)	kJ/m ²	ISO 179
THERMAL PROPERTIES			
Heat Distortion Temperature	--	--	--
HDT 120°C/h at 455kPa (B)	205	°C	ISO 75/1
HDT 120°C/h at 1820kPa (A)	70	°C	ISO 75/1
Softening temperature	--	--	--
Vicat 50°C/h at 9,81N (A)	--	°C	ISO 306
Vicat 50°C/h at 49,05N (B)	>210	°C	ISO 306
FLAMMABILITY PROPERTIES			
Flammability	--	--	--
GWFI at 2 mm	750	°C	IEC 60695-2-12
UL94 at 1.6 mm	V2	--	UL94
HARDNESS			
Hardness Shore D (15 s)	--	Shore D	ISO 7619-1
ADDITIONAL INFORMATION			
"^" = additive# 0-9, no effect on material prop.	--	--	--
Filler content	--	±2%	ISO 3451
Mould shrinkage (with flow)	1,2	%	Polykemi
Mould shrinkage (across flow)	1,5	%	Polykemi

Stated values in this datasheet are approximate. The values originate, if nothing else is stated, from standardized test specimens in natural color. All information, recommendations and advice, written or verbal, given by an individual company within, or agent affiliated with, The Polykemi Group are according to our knowledge to the date of this edition, correct and given in good faith. It is the responsibility of the customer to test and evaluate if the material suits the application and the environment in which it is intended to be used. Companies within, or agent affiliated with, The Polykemi Group can not be held responsible or liable for any loss incurred through incorrect or faulty use of the products. When producing details in flame retardant material, corrosion protected steel is to recommend for the mould.

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rondo scanfill

Feature	Value	Unit	Testmethod
PROCESS INSTRUCTIONS			
Drying time	2-8	h	--
Drying temperature	75	°C	--
Maximal moisture content	<0,1	%	--
Melt temperature	280-300	°C	--
Mould temperature	70-120	°C	--
Peripheral screw speed	300-500	mm/s	--
Back pressure	60-100	bar	--

Values within (): 23°C, 50% RH, 24h

Further material information is available upon request

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